

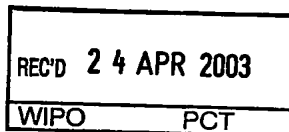
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Rec'd PTO 17 JUN 2005  
PCT/SG 03/00076

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Date of Filing : 12 SEPTEMBER 2002 (12-09-2002)  
Application number : 200205490-6  
Applicants : MALAYSIA WOODWORKING (PTE) LTD  
Title of Invention : METHOD AND APPARATUS FOR  
ASSEMBLING A 2-PIECE SKIN DOOR



A handwritten signature in cursive script, appearing to read "Serene Chan".

**Serene Chan (Miss)**  
Assistant Registrar  
For Registrar of Patents  
Singapore

15 April 2003

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INTELLECTUAL PROPERTY OFFICE OF SINGAPORE  
REQUEST FOR THE GRANT OF A PATENT UNDER  
SECTION 25



\* denotes mandatory fields

1. YOUR REFERENCE\*

1237.P002/LYH/fmy

2. TITLE OF  
INVENTION\*

METHOD AND APPARATUS FOR ASSEMBLING A 2-PIECE SKIN DOOR

3. DETAILS OF APPLICANT(S)\* (see note 3)

Number of applicant(s)

1

(A) Name

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SINGAPORE 739552

State

SG

Country

SG

☒

For corporate applicant

☐

For individual applicant

State of incorporation

SG

State of residency

Country of incorporation

SG

Country of residency

☐

For others (please specify in the box provided below)

(B) Name

Address

State

Country



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12 SEP 2002



☐ For corporate applicant

☐ For individual applicant

State of incorporation

State of residency

Country of incorporation

Country of residency

☐ For others (please specify in the box provided below)

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Address

State

Country

☐ For corporate applicant

☐ For individual applicant

State of incorporation

State of residency

Country of incorporation

Country of residency

☐ For others (please specify in the box provided below)

☐

Further applicants are to be indicated on continuation sheet 1

**4. DECLARATION OF PRIORITY (see note 5)**

A. Country/country designated

File number

Filing Date

DD MM YYYY

B. Country/country designated

File number

Filing Date

DD MM YYYY

☐

Further details are to be indicated on continuation sheet 6

**5. INVENTOR(S)\* (see note 6)**

A. The applicant(s) is/are the sole/joint inventor(s)

Yes

☐

No

☒

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B. A statement on Patents Form 8 is/ will be furnished

Yes

☒

No

☐

6. CLAIMING AN EARLIER FILING DATE UNDER (see note 7)

☐

section 20(3)

☐

section 26(6)

☐

section 47(4)

Patent application number

DD MM YYYY

Filing Date

Please mark with a cross in the relevant checkbox provided below  
(Note: Only one checkbox may be crossed.)

☐

Proceedings under rule 27(1)(a)

DD MM YYYY

Date on which the earlier application was amended

☐

Proceedings under rule 27(1)(b)

7. SECTION 14(4)(C) REQUIREMENTS (see note 8)

Invention has been displayed at an international exhibition.

Yes

☐

No

☒

8. SECTION 114 REQUIREMENTS (see note 9)

The invention relates to and/or used a micro-organism deposited for the purposes of disclosure in accordance with section 114 with a depository authority under the Budapest Treaty.

Yes

☐

No

☒

9. CHECKLIST\*

(A) The application consists of the following number of sheets

i.	Request	<input type="text" value="5"/>	Sheets
ii.	Description	<input type="text" value="12"/>	Sheets
iii.	Claim(s)	<input type="text" value="5"/>	Sheets
iv.	Drawing(s)	<input type="text" value="7"/>	Sheets
v.	Abstract (Note: The figure of the drawing, if any, should accompany the abstract)	<input type="text" value="1"/>	Sheets
Total number of sheets		<input type="text" value="30"/>	Sheets

(B) The application as filed is accompanied by:

☐

Priority document(s)

☐

Translation of priority document(s)

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☐

Statement of inventorship  
& right to grant

☐

International exhibition certificate

10. DETAILS OF AGENT (see notes 10, 11 and 12)

Name

Firm

LAWRENCE Y D HO & ASSOCIATES PTE LTD

11. ADDRESS FOR SERVICE IN SINGAPORE\* (see note 10)

Block/Hse No.

30

Level No.

07

Unit No./PO Box

01

Street Name

BIDEFORD ROAD

Building Name

THONGSIA BUILDING

Postal Code

229922

12. NAME, SIGNATURE AND DECLARATION (WHERE APPROPRIATE) OF APPLICANT OR AGENT\* (see note 12)

(Note: Please cross the box below where appropriate.)

☒

I, the undersigned, do hereby declare that I have been duly authorised to act as representative, for the purposes of this application, on behalf of the applicant(s) named in paragraph 3 herein.



DD MM YYYY

11 09 2002

Name and Signature

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**NOTES:**

1. This form when completed, should be brought or sent to the Registry of Patents together with the rest of the application. Please note that the filing fee should be furnished within the period prescribed.
2. The relevant checkboxes as indicated in bold should be marked with a cross where applicable.
3. Enter the name and address of each applicant in the spaces provided in paragraph 3.  
Where the applicant is an individual  
- Names of individuals should be indicated in full and the surname or family name should be underlined.  
- The address of each individual should also be furnished in the space provided.  
- The checkbox for "For individual applicant" should be marked with a cross.  
  
Where the applicant is a body corporate  
- Bodies corporate should be designated by their corporate name and country of incorporation and, where appropriate, the state of incorporation within that country should be entered where provided.  
- The address of the body corporate should also be furnished in the space provided.  
- The checkbox for "For corporate applicant" should be marked with a cross.  
  
Where the applicant is a partnership  
- The details of all partners must be provided. The name of each partner should be indicated in full and the surname or family name should be underlined.  
- The address of each partner should also be furnished in the space provided.  
- The checkbox for "For others" should be marked with a cross and the name and address of the partnership should be indicated in the box provided.
4. In the field for "Country", please refer to the standard list of country codes made available by the Registry of Patents and enter the country code corresponding to the country in question.
5. The declaration of priority in paragraph 4 should state the date of the previous filing, the country in which it was made, and indicate the file number, if available. Where the application relied upon in an International Application or a regional patent application e.g. European patent application, one of the countries designated in that application (being one falling under section 17 of the Patents Act) should be identified and the country should be entered in the space provided.
6. Where the applicant or applicants is/are the sole inventor or the joint inventors, paragraph 5 should be completed by marking with a cross the 'YES' checkbox in the declaration (A) and the 'NO' checkbox in the alternative statement (B). Where this is not the case, the 'NO' checkbox in declaration (A) should be marked with a cross and a statement will be required to be filed on Patents Form 8.
7. When an application is made by virtue of section 20(3), 26(6) or 47(4), the appropriate section should be identified in paragraph 6 and the number of the earlier application or any patent granted thereon identified. Applicants proceeding under section 26(6) should identify which provision in rule 27 they are proceeding under. If the applicants are proceeding under rule 27(1)(a), they should also indicate the date on which the earlier application was amended.
8. Where the applicant wishes an earlier disclosure of the invention by him at an International Exhibition to be disregarded in accordance with section 14(4)(c), then the 'YES' checkbox at paragraph 7 should be marked with a cross. Otherwise, the 'NO' checkbox should be marked with a cross.
9. Where in disclosing the invention the application refers to one or more micro-organisms deposited with a depository authority under the Budapest Treaty, then the 'YES' checkbox at paragraph 8 should be marked with a cross. Otherwise, the 'NO' checkbox should be marked with a cross. Attention is also drawn to the Fourth Schedule of the Patents Rules.
10. Where an agent is appointed, the fields for "DETAILS OF AGENT" and "ADDRESS FOR SERVICE IN SINGAPORE" should be completed and they should be the same as those found in the corresponding Patents Form 41. In the event where no agent is appointed, the field for "ADDRESS FOR SERVICE IN SINGAPORE" should be completed, leaving the field for "DETAILS OF AGENT" blank.
11. In the event where an individual is appointed as an agent, the sub-field "Name" under "DETAILS OF AGENT" must be completed by entering the full name of the individual. The sub-field "Firm" may be left blank. In the event where a partnership/body corporate is appointed as an agent, the sub-field "Firm" under "DETAILS OF AGENT" must be completed by entering the name of the partnership/body corporate. The sub-field "Name" may be left blank.
12. Attention is drawn to sections 104 and 105 of the Patents Act, rules 90 and 105 of the Patents Rules, and the Patents (Patent Agents) Rules 2001.
13. Applicants resident in Singapore are reminded that if the Registry of Patents considers that an application contains information the publication of which might be prejudicial to the defence of Singapore or the safety of the public, it may prohibit or restrict its publication or communication. Any person resident in Singapore and wishing to apply for patent protection in other countries must first obtain permission from the Singapore Registry of Patents unless they have already applied for a patent for the same invention in Singapore. In the latter case, no application should be made overseas until at least 2 months after the application has been filed in Singapore, and unless no directions had been issued under section 33 by the Registrar or such directions have been revoked. Attention is drawn to sections 33 and 34 of the Patents Act.
14. If the space provided in the patents form is not enough, the additional information should be entered in the relevant continuation sheet. Please note that the continuation sheets need not be filed with the Registry of Patents if they are not used.

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METHOD AND APPARATUS FOR ASSEMBLING A 2-PIECE SKIN DOOR

Technical Field

5

This invention relates to a method for assembling a 2-piece skin door, particularly a metal door which skins have been pre-formed. It also relates to an apparatus and its various embodiments adapted for carrying out the process.

10

Background of Invention

15 Metal doors may be fabricated from two or more skins parts. Each of the skins' edges are usually folded to form a profile which would complementarily engage one another to form an interlocking seam.

20 One example of such metal door construction is shown in FIGURE 1 which comprised of a bottom skin (10) and a top skin (20). Conventionally, the edge portions of a completely installed door as shown in the Fig. 1 may be referred to as the *stile* or *longitudinal edge* (12, 22) (the latter term is used in this specification) and the *rail* (14, 24) or the  
25 vertical edge (the former term is used in this specification).

30 The longitudinal edges (12, 22) of the skins are folded in a profile that will complementarily hem or lock each other when engaged. One such example is shown in Fig. 1 wherein the bottom skin's opposing longitudinally edges (12) are each bent upwardly (15) to form the full thickness of the door edge and the ends of the bent portion is folded outwardly to

form an downward flange (17) which is flush with the outer door edge.

5 The top skin's longitudinal edges may be bent downwardly (23) to form less than the full thickness of the door edge. Fig. 1 shows an example of the thickness of the top skin's longitudinal edge to be about half the full thickness of the door edge. The ends of the bent portion is then folded inwardly to form an upward flange (25) which, upon engaging  
10 the corresponding downward flange (17) of the bottom skin edge, complementarily interlock with the bottom skin's folded ends to form the door edge seam.

To assemble the two pieces of skins together by slotting in  
15 the flanges (17, 25) of the skins into a mutually hemming or interlocking arrangement, one may manually align the edge profiles of the skins end-to-end and push to slot in the flanges. Manual assembly is usually tedious and laborious.

20 It is therefore the object of the present invention to provide a method of assembling a two-piece skin door in a mechanised or automated manner. It is a further object of the present invention to provide an apparatus for carrying out the method of assembly in an automated or mechanical  
25 manner.



Statement of Invention

- Accordingly, the present invention provides for a method and apparatus for assembling a 2-piece skin door comprising a bottom skin and a top skin wherein each of the bottom and top skins' longitudinal edges have been bent and folded to complementarily hem each other in an interlocking manner to form a seam, the method including:
- 10 - holding the bottom skin in an upwardly open pan manner;
  - holding the top skin in an inverted pan manner wherein its folded and hemmed edges are aligned with the corresponding edges of the bottom skin; and
  - 15 - pushing the top skin to insert said top skin's folded edge into the bottom skin's corresponding folded edge to form said interlocking seam.

- The bottom skin's longitudinally edges may bent upwardly to form the full thickness of the door edge and the ends of the bent portion is folded outwardly to form an downward flange which is flush with the outer door edge; and
- 20 - the top skin's longitudinal edges are bent downwardly to form less than, preferably half of, the full thickness of the door edge and the ends of the bent portion is folded inwardly to form an upward flange to complementarily interlock with the bottom skin's folded ends to form the door edge.

- Preferably, the interlocking seams are provided at diagonally-opposing edges of the assembled door comprising of the top and bottom skins.

The bottom skin may be held securely on a substantially planar surface with securing means. The top skin may be

provided with means for pulling it in alignment towards the bottom skin by winch and cable with hook means.

In one embodiment, the pulling means comprises at least a winch capable of winding a cable attached to a bar arranged to push the top skin in alignment towards the bottom skin. Preferably, it is employed in conjunction with a second winch pulling a bar to push the top skin.

In another alternative embodiment, a second winch is substituted with a reversible rotation motor and the cable forms a loop around the distal half of the planar surface so that the pushing bar may be withdrawn from a completely assembled door back to the distal end to enable the next top skin to be placed onto said distal planar surface.

#### Brief Description of Drawings

The aforesaid objects and advantages of the method and apparatus may be better understood by referring to the following drawings, and its accompanying description of the representative or exemplary embodiments in which:

- FIGURE 1 (discussed in *Background of Invention* above) shows the parts of a two-piece skin door;
- FIGURE 1A shows in detail the seam joint of an assembled door edge comprising two skins;
- FIGURE 1B shows a cross-sectional perspective view of an assembled door comprising two skins and joined at diagonally-opposing edges;
- FIGURE 1C shows a cross-sectional perspective view of an assembled door comprising a pan skin and cover skin joined at parallel edges;

- FIGURE 1D shows part of an assembled door with a seam joint at a rebate meeting edge;
- FIGURE 2 shows a plan view of an apparatus employing the method of the invention;
- 5 FIGURE 3 shows an elevation view of the arrangement of Fig. 2;
- FIGURE 4 shows a plan view of another apparatus employing the method of the invention; and
- FIGURE 5 shows an elevation view of the arrangement of
- 10 Fig. 4.

### Detailed Description of Specific Embodiments

5 In general, the method according to the present invention for assembling a 2-piece skin door is applicable for those skins wherein the longitudinal edges have been bent and folded to complementarily hem each other in an interlocking manner to form a seam.

10 It is apparent that many types and arrangements of seam joints are possible. FIGURE 1A shows in detail the seam joint (9) of an assembled door edge comprising two skins (10, 20). This arrangement, whereby the longitudinal edge of the respective skins are bent and folded to complementarily hem  
15 each other in an interlocking manner to form a seam joint, is also known as the "Pittsburg" or "grooved seam" joint.

One preferred example of such joint in a cross-sectional  
20 perspective view in FIGURE 1B wherein an assembled door comprising two skins (10, 20) is shown joined at diagonally-opposing edges (9). FIGURE 1C shows a cross-sectional perspective view of an assembled door comprising a pan skin (20) and cover skin (10) joined at parallel edges (9).

25 For a rebate meeting edge of a door, FIGURE 1D shows an example in which the mutually hemming or interlocking grooved seam joint (9) may be provided. As shown, the seam joint's folding may be provided to extend so that the folds displace  
30 into the door so that the rebate meeting edge's external surface remains flush.

The following embodiments shall use the example of the skin profiles of the bottom skin and top skin as described in the

*Background of the Invention* above, with reference to Fig. 1, i.e.

- 5 - the bottom skin's opposing longitudinally edges (12) are each bent upwardly (15) to form the full thickness of the door edge; the end of the bent portion is then folded outwardly to form an downward flange (17) which is flush with the outer door edge; and
- 10 - the top skin's longitudinal edges are bent downwardly (23) to form less than the full thickness of the door edge. Fig. 1 shows the thickness to be about half the full thickness of the door edge. The ends of the bent portion is then folded inwardly to form an upward flange (25) which, upon engaging  
15 the corresponding downward flange (17) of the bottom skin edge, complementarily interlock with the bottom skin's folded ends to form the door edge seam.

The method generally comprises holding the bottom skin (10)  
20 in an upwardly open pan manner and holding the top skin (20) in an inverted pan manner so that its folded and hemmed edges (22) are aligned with the corresponding edges (12) of the bottom skins. In this position, the top skin (20) may then be pushed to insert its folded edges (12) into the  
25 corresponding folded edges (12) of the bottom skin (10) to form an interlocking seam of the door edge.

It will be appreciated that the top skin's longitudinal edges may be bent downwardly to form a thickness edge that is less  
30 than the full thickness of the door edge. The ends of the bent portion may be folded inwardly to form an inward flange (25) that complementarily interlock or mutually hem the bottom skin's folded ends to form the door edge. Fig. 1

shows the preferable thickness of the top skin's edge, i.e. about half the thickness of the door edge.

For ease of holding the bottom skin (10) in a secure manner,  
5 it is preferable that the skin is held on a substantially planar surface such as an assembly bench (30) as shown in FIGURE 2 (elevation view) with securing means. The corresponding plan view of Fig. 2 is shown in FIGURE 3.

10 Figure 3 shows one example of the securing means being retaining guides (32, 34) flanking the bottom skin on 3 sides, i.e. on either sides of its longitudinal edges (34) and on the proximal end (32). These guides serve to retain and secure the bottom skin in a fixed position in alignment  
15 for the top skin (20) to be pushed to insert the latter's folded edge into the former's folded edge.

The distal rail end of bottom skin (10) may preferably be provided with means to further securely hold that end onto  
20 the assembly bench (30). Examples of such securing means may be hook (36) and eyelet (38) means whereby one or more eyelets (38) is provided at the distal rail end and hooked up to a clamp, vise or like means with adjustable screw and handle (40) for tightening or releasing the hook's holding  
25 onto the eyelet. The clamp means (40) may be mounted onto the assembly bench (30) at a level below the top skin laid on the assembly bench so as not to obstruct the path of the top skin being moved to be assembled onto the bottom skin. Preferably, the clamp means (40) is mounted below the  
30 assembly bench (30) as shown in Fig. 2.

In another preferred embodiment, a protrusion from the distal rail end of the bottom skin may be provided whereby an eyelet is provided thereon for ease of attaching the hook. The

protrusion may be a plate (42) welded onto the rail edge and allowed to protrude therefrom as shown in Fig. 2.

The assembly bench may be provided as a long planar surface  
5 with an elongation sufficient to lay down a bottom skin  
and/or top skin in an end-to-end arrangement including any  
assembling devices or attachments. Although the drawings  
herein show separate assembly benches for the bottom and top  
skins, a combined continuous bench may be used provided  
10 openings are allowed in between the laid bottom and top skins  
for the hook and clamp means (40) and other devices such as  
pulling cables (described below) to go through.

To facilitate the ease of the laid top skin's movement atop  
15 the bench, a plurality roller means (41) may be provided.

Just as in the case of the protrusions from the distal rail  
edge of the bottom skin (10), similar protrusions may be  
provided from the proximal rail edge of the top skin. The  
20 protrusions may similarly be plates (44) provided with  
eyelets (45) and welded onto the top skin's rail edge while  
hook means (46) may be provided to engage the eyelets (45).  
However, unlike the bottom skin (10) where the plates (42)  
are used for securing the skin onto the bench (30), the top  
25 skin's hook means (46) may be linked to pulling means to pull  
the skin in alignment with the bottom skin (10) so that the  
latter's folded edge may receive the former's.

As shown in Fig. 2, the hook (46) may be connected to a cable  
30 (48) which may be extended over the proximal edge of the  
bench to thereunder via pulley guides where a pulling device  
such as a winch (52) may be mounted. The activation of the  
winch (52) will pull the top skin (20) via the hook (46) and

cable (48) towards the bottom skin (10) and insert the top skin's folded edge (22) into that of the bottom skin (12).

5 In addition to the action of pulling of the top skin forward, pushing action may also be employed to move the top skin towards the bottom skin. This pushing action may be employed either independently (i.e. dispense with the pulling means) or in conjunction with the pulling means.

10 As shown in Figs. 2 and 3, a second winch and cable (60) arrangement may be provided to pull an end pushing bar (62) via a T-shape bar (64) which length transcend the elongation of the top skin. The end of the bar (64) may be provided with an eyelet and hook means for enabling the cable to pull  
15 the end pushing bar (62) which in turn pushes the top skin.

It will be appreciated that the first and second winching arrangements may be operable using two separate winches as shown in the figures, or using a single winch having extended  
20 axle and gear means to work separate pulley arrangements in pulling the top skin and the end push bar separately but in tandem.

Another alternative arrangement for the second winch is shown  
25 in FIGURE 4 and FIGURE 5 in elevation and plan views respectively. In this alternative embodiment, the second winch (70) is mounted below the distal portion of the assembly bench (60) and the cable (72) may be arranged to pull at a level below the top skin being laid on the bench  
30 (60). For ease of the cable arrangement to be wound around the edge of the bench by the second winch (70), split bench or separate benches for the bottom and top skins is preferable. The cable (72) may be connected to the end push



bar (62) to pull it in order to provide the requisite pushing force on the top skin (20).

As is apparent from the plan view in Fig. 5, the cable (72) may be arranged to extend through the centre of the distal assembly bench. To accommodate the cable (72), the rollers may be split in length so that each row comprises a pair of rollers (41a, 41b) allowing for a gap in between the pairs for the cable flow to be attached to the end push bar (62).

As only one point of attachment or transfer of force is provided by such arrangement, i.e. at the centre of the bar, it would be preferable that the bar (62) be pulled at an even manner to push the distal rail edge (24) of the top skin. To this end, end push bar (62) may be provided with a cross bar (74) which ends are provided with means to slide along rail guides (76) along the longitudinal sides of the bench.

The second winch may be advantageously substituted with a reversible rotation motor and the cable (72) forms a loop around the distal portion of the bench (60) so that the push end bar may be moved in either direction, i.e. operable to push the top skin towards the bottom skin in the same direction as the second winch, or to withdraw the end push bar (62) by pulling in the reverse direction so that a next top skin may be laid on the bench after the first top skin has been fully assembled onto the bottom skin. The second winch may also be switched off and the end push bar pulled back manually.

The end push bar may optionally be provided with additional hook means (78) which may be employed to separate the bottom and top door skin for whatever reasons, e.g. a jammed, damaged or incomplete assembly of skins. The half- or incompletely-assembled door may be lifted off the bench and

turned around with the proximal rail edge of the top skin (i.e. with the protruding plates) towards the end push bar (62). The additional hook means (78) may then be hooked onto plates (44) protruding from the rail edge (24) of the top skin (20). The withdrawal of the end push bar (62) with the additional hooks (78) attached to the protruding plates (44) of the top skin (20) will then pull out the top skin and separates it from the bottom skin (10).

10 It will be apparent to a skilled person that there is number of alternative ways of achieving the various features of the present invention. For example, the reversible pull of the cable by the second winch may, instead of the above-suggested substitution with a reversibly-operated motor, be provided  
15 with gear arrangement for reverse rotation to reverse the direction of the cable pull.

It will also be obvious to a person skilled in the art that the various methods of the present invention and its various  
20 specific embodiments and configurations of the apparatus and components thereof may be varied or modified without departing from the above-described method or working principle. These and other such embodiments not specifically described herein are not to be considered as departures from  
25 the present invention and shall be considered as falling within the letter and spirit of the following claims.

CLAIMS

- 5 1. A method for assembling a 2-piece skin door comprising a bottom skin and a top skin wherein each of the bottom and top skins' longitudinal edges have been bent and folded to complementarily hem each other in an interlocking manner to form a seam, the method including:
- 10 - holding the bottom skin in an upwardly open pan manner;  
- holding the top skin in an inverted pan manner wherein its folded and hemmed edges are aligned with the corresponding edges of the bottom skin; and  
- pushing the top skin to insert said top skin's folded edge  
15 into the bottom skin's corresponding folded edge to form said interlocking seam.
2. A method according to Claim 1 wherein:  
- the bottom skin's longitudinally edges are each bent  
20 upwardly to form the full thickness of the door edge and the ends of the bent portion is folded outwardly to form an downward flange which is flush with the outer door edge; and  
- the top skin's longitudinal edges are bent downwardly to form less than the full thickness of the door edge and the  
25 ends of the bent portion is folded inwardly to form an upward flange to complementarily interlock with the bottom skin's folded ends to form the door edge.
3. A method according to Claim 2 wherein the top skin's  
30 longitudinal edges are bent downwardly to form about half the thickness of the door edge.

3A. A method according to Claim 1 wherein the interlocking seams are provided at diagonally-opposing edges of the assembled door comprising of the top and bottom skins.

4. A method according to Claim 1 wherein the bottom skin is held securely on a substantially planar surface with securing means.

5. A method according to Claim 4 wherein the securing means secure the bottom skin by fastening onto at least a protrusion from the rail edges of said skin.

6. A method according to Claim 5 wherein the protrusion is a protruding plate welded onto the inside of the bottom skin and provided with eyelets for hook means to fasten thereunto.

7. A method according to Claim 1 wherein the top skin is provided with at least a protrusion from the rail edge of said skin and pulling means is provided to fasten onto said protrusion and to pull said skin in alignment towards the bottom skin.

8. A method according to Claim 7 wherein the protrusion is a protruding plate welded onto the inside of the top skin and provided with eyelets for hook means to fasten thereunto.

9. A method according to any one of Claims 7 and 8 wherein the pulling means comprises at least a winch capable of winding a cable attached to said hook means to pull said top skin.

10. A method according to any one of Claims 7 to 9 wherein the pulling means comprises at least a winch capable of winding a cable attached to a bar arranged to push the top skin in alignment towards the bottom skin.

11. A method according to Claims 9 and 10 wherein a first winch pulling the top skin is employed in conjunction with a second winch pulling a bar to push said top skin.

5

12. A method according to Claim 11 wherein the second winch is mounted distal to the full length of the bottom skin underneath the planar surface which provides for a break in the surface for the flow of cable being winched by said second winch.

10

13. A method according to Claim 12 wherein the second winch is substituted with a reversible rotation motor and the cable forms a loop around the distal half of the planar surface so that the pushing bar may be withdrawn from a completely assembled door back to the distal end to enable the next top skin to be placed onto said distal planar surface.

15

14. An apparatus for assembling a 2-piece skin door comprising a bottom skin and a top skin wherein each of the bottom and top skins' longitudinal edges have been bent and folded to mutually hem each other to form a door edge seam when slotted into one another, said apparatus including:

20

- a planar surface area sufficient for laying each a bottom and a top skins longitudinally end to end, said surface comprising

25

- a proximal surface portion for laying the bottom skin in an upwardly open pan manner;

- a distal surface portion for laying the top skin in an inverted pan manner;

30

- fastening means for securely holding the bottom skin onto said proximal surface with its folded edges in alignment with the corresponding folded edges of the top skin;

- means for moving the aligned top skin to insert said top skin's folded edge into the bottom skin's corresponding folded edge to form said door edge seam.

5 15. An apparatus according to Claim 14 wherein the fastening means comprises hook, cable and screw means to hold onto protrusions from the bottom skin.

10 16. An apparatus according to Claim 14 wherein the means for moving the top skin comprises at least a winch mounted below the proximal end of the planar surface and is capable of moving said top skin so that said top skin's folded edges may be received into the corresponding bottom skin's folded edges by winding a cable attached to a hook means fastened to a  
15 protrusion from the proximal rail edge of said top skin.

17. An apparatus according to any one of Claims 14 and 16 wherein the protrusion comprises at least one plate welded onto the rail edge of the top skin to protrude therefrom.

20 18. An apparatus according to Claim 14 wherein the means for moving the top skin comprises at least a winch mounted below the proximal end of the planar surface and is capable of pushing the top skin so that said top skin's folded edges  
25 maybe received into the corresponding bottom skin's folded edges by winding a cable attached to an end push bar to push the distal rail edge of said top skin.

30 19. An apparatus according to Claim 18 the planar surface is provided with an opening between the proximal and distal surface portions to allow for cables to be pulled by a winch mounted below the distal surface portion.

20. An apparatus according to Claim 19 wherein the proximal and distal surface portions are each detached bench surface portions.

5 21. An apparatus according to any one of Claims 14, 19 and 20 wherein the means for moving the top skin comprises the end push bar connected to an endless cable pulled by a reversible motor.

10 22. An apparatus according to any one of Claims 14 to 21 wherein guide means are provided to secure and align the bottom skin to receive the top skin and to guide the end push bar's movement.

15 23. A door assembled according to a method of any one of Claims 1 to 13.

24. A door assembled with an apparatus according to any one of Claims 14 to 22.



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18



\*162162\*

Abstract

METHOD AND APPARATUS FOR ASSEMBLING A 2-PIECE SKIN DOOR

5

A method and apparatus for assembling a 2-piece skin door comprising a bottom skin (10) and a top skin (20) wherein each of the bottom and top skins' longitudinal edges have been bent and folded to complementarily hem each other in an interlocking manner to form a seam, the method including:

- holding the bottom skin in an upwardly open pan manner;
- holding the top skin in an inverted pan manner wherein its folded and hemmed edges are aligned with the corresponding edges of the bottom skin; and
- pushing the top skin to insert said top skin's folded edge into the bottom skin's corresponding folded edge to form said interlocking seam.

20

The bottom skin may be held securely on a substantially planar surface with securing means. The top skin may be provided with means for pulling it in alignment towards the bottom skin by winch and cable with hook means.

25

FIGURE 2



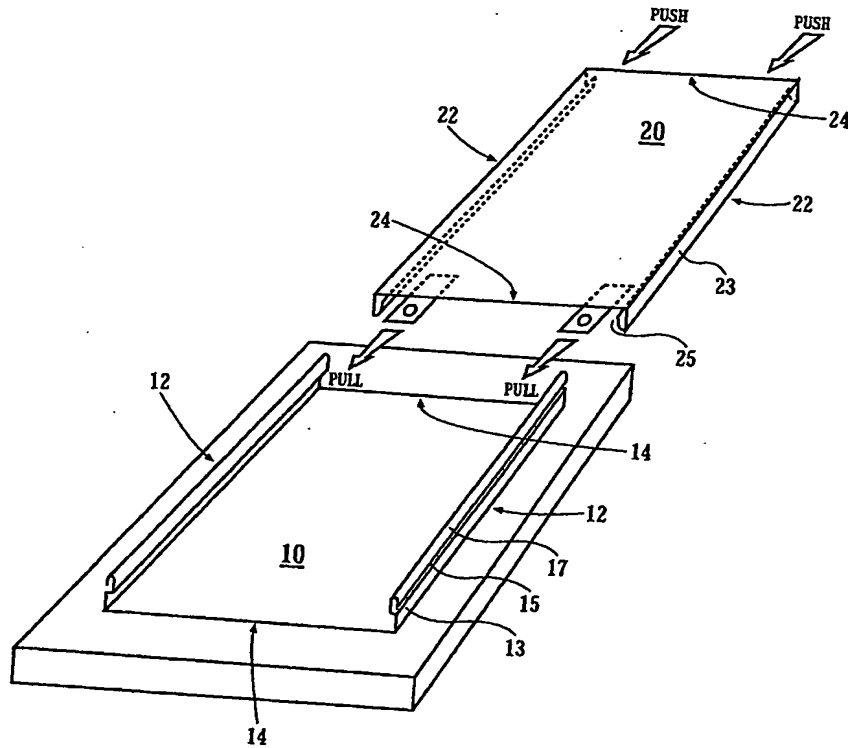


\*G00002\*



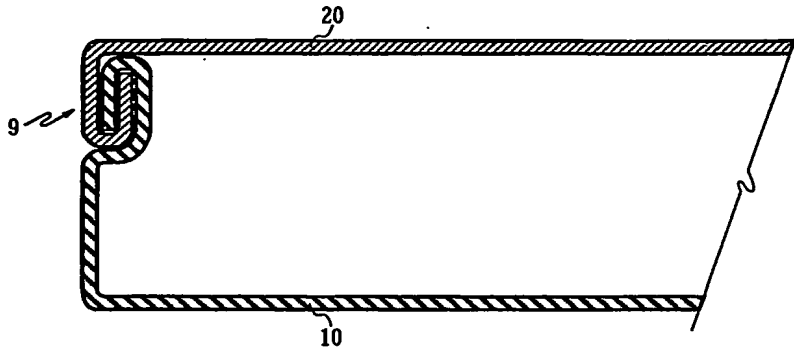
\*163163\*

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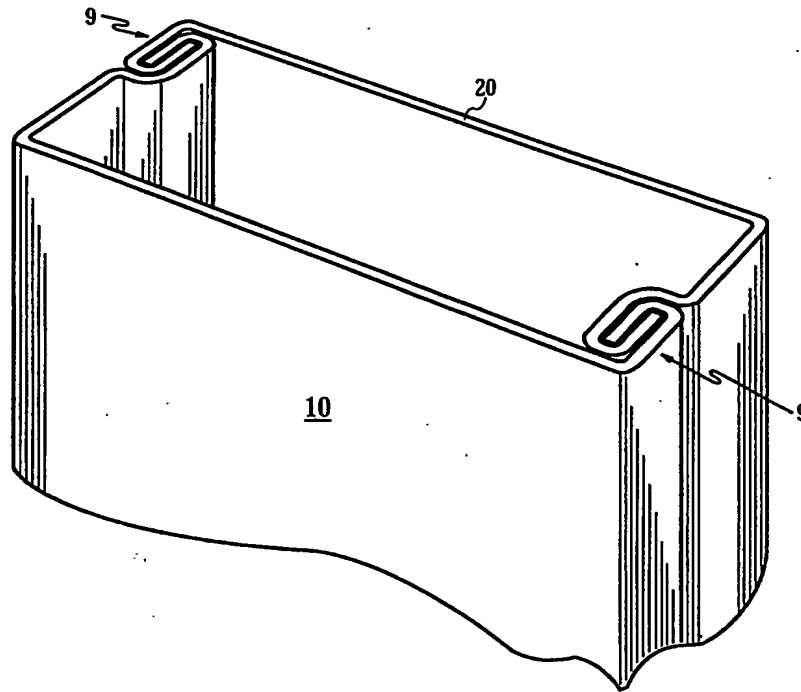


**FIG. 1**

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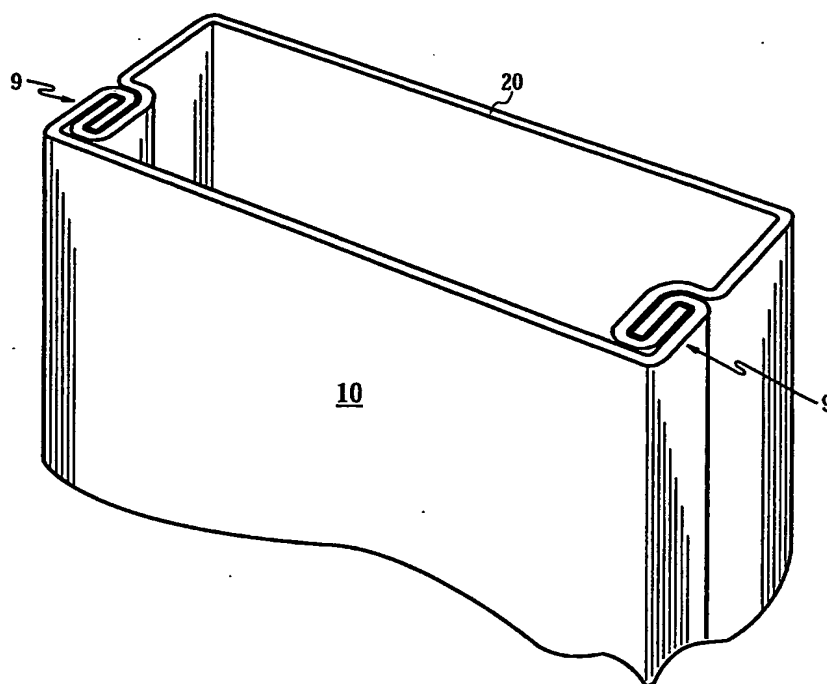


**FIG. 1A**

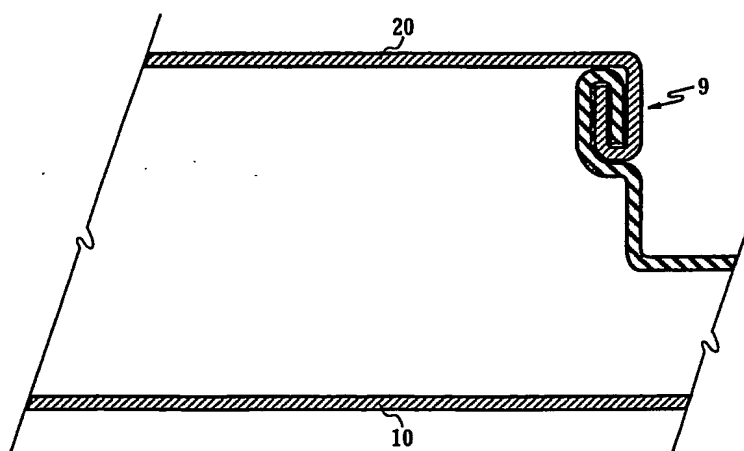


**FIG. 1B**

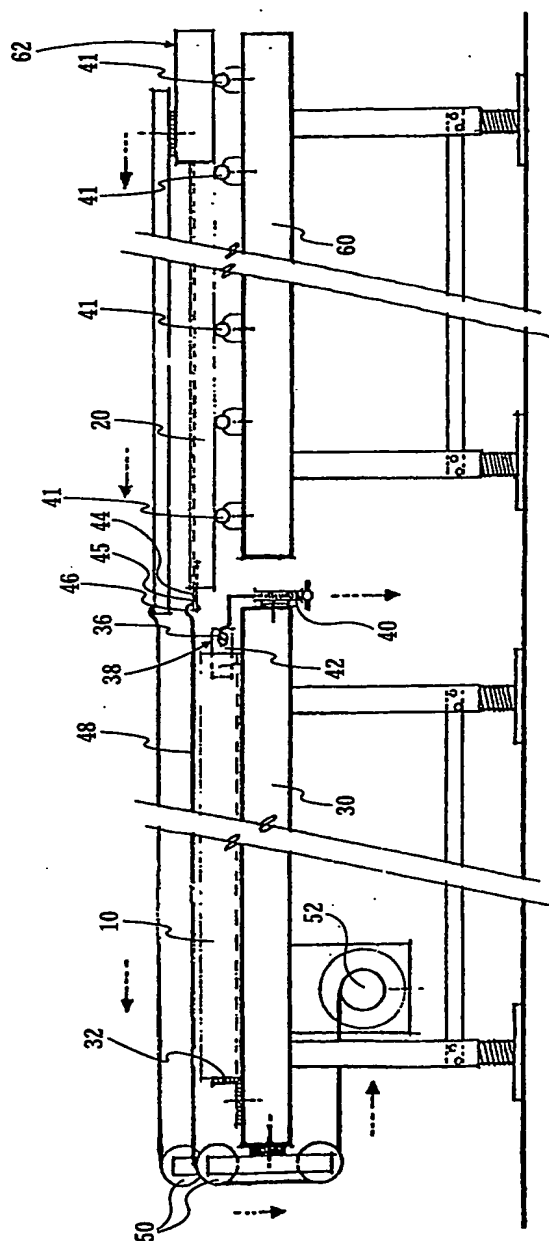
- 3/7 -



**FIG. 1C**



**FIG. 1D**



**FIG. 2**

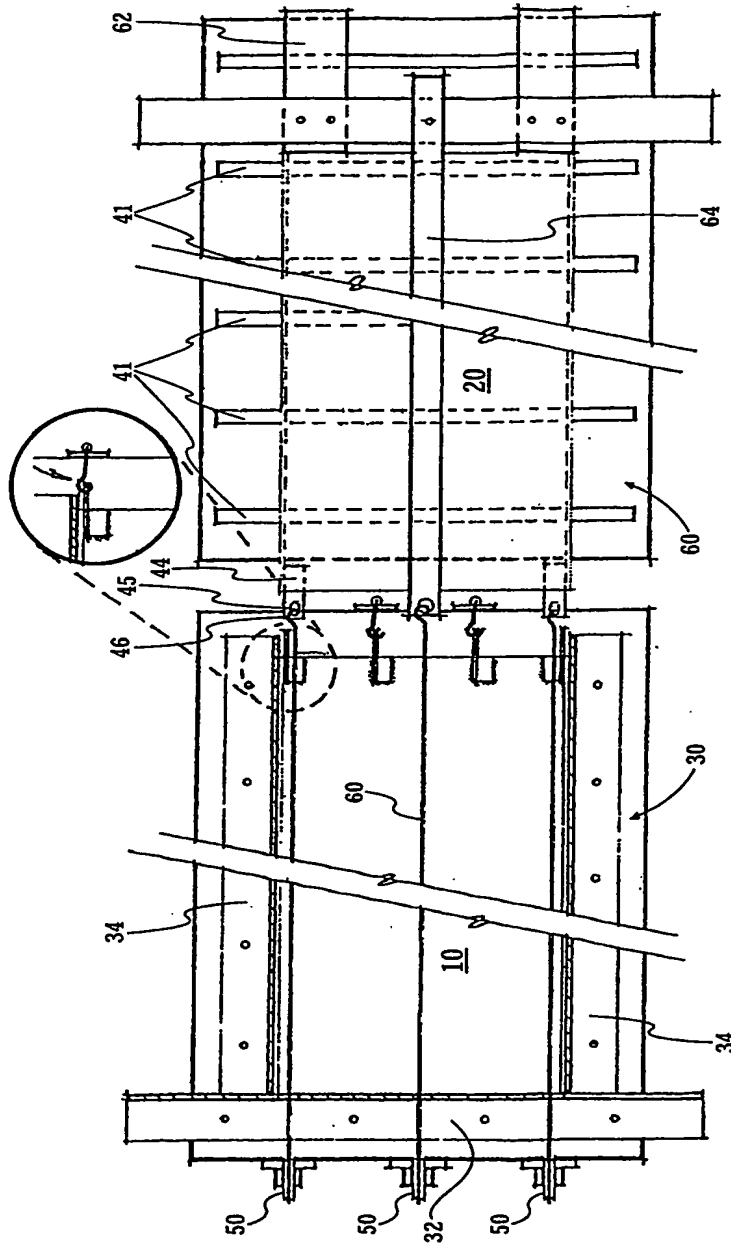


FIG. 3

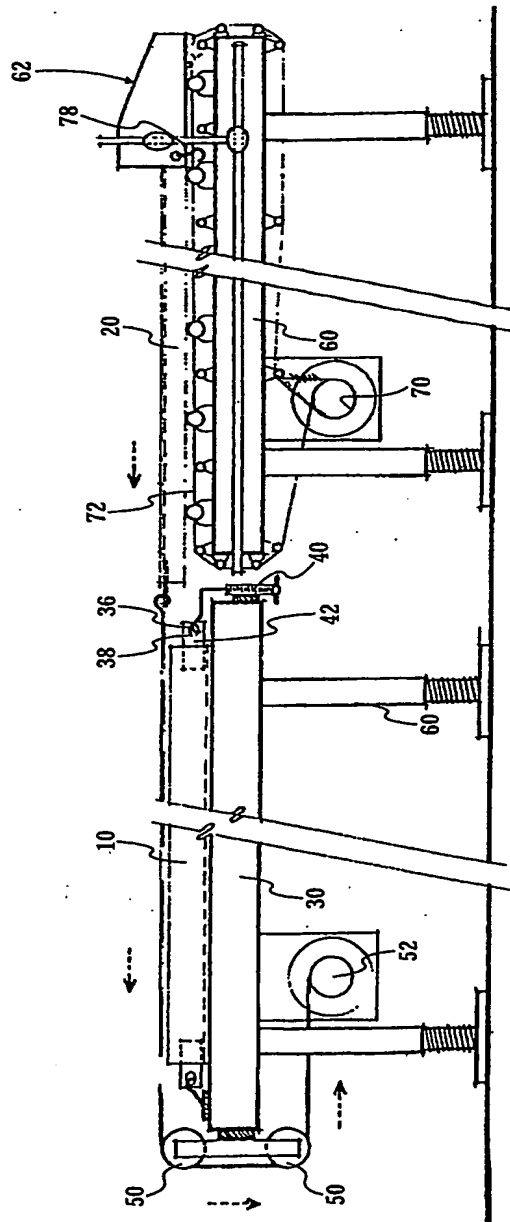


FIG. 4

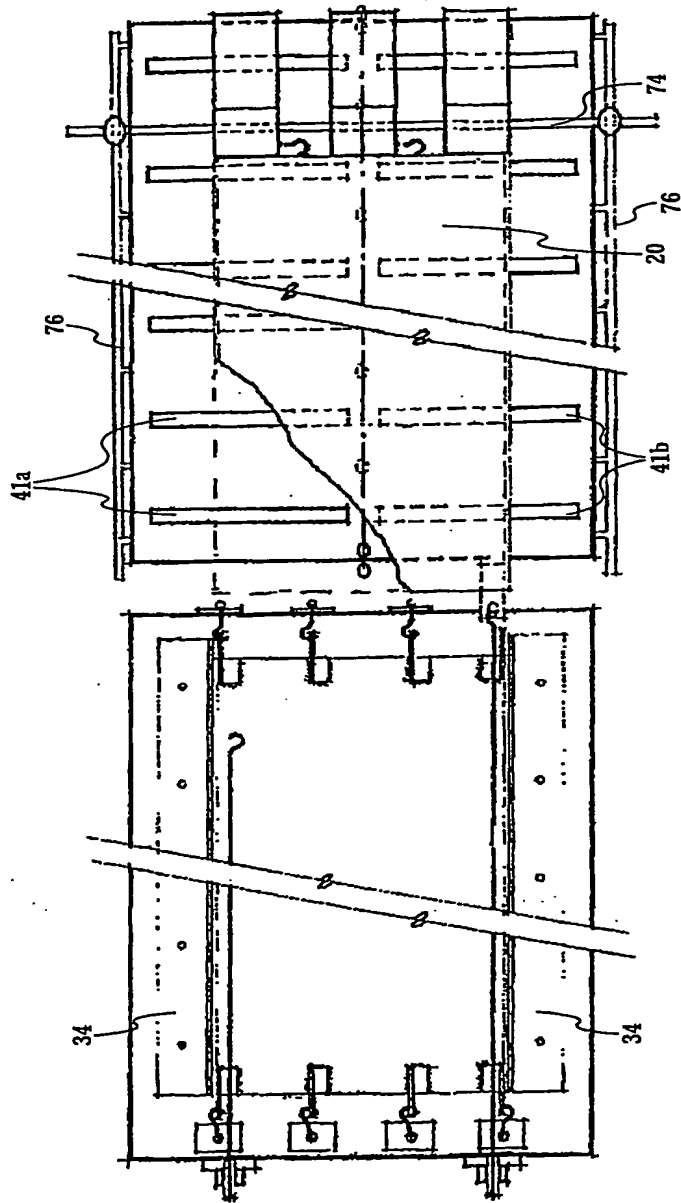


FIG. 5

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